

**USDA, AMS,
Livestock and Seed Program**

APPROVED

**ITEM DESCRIPTION AND
CHECKLIST OF REQUIREMENTS
(IDCR) FOR
Lean Beef Patties A580**

Contracting Officer Technical Representative (COTR):

Standards, Analysis, and Technology Branch
Room 2607, Phone: (202) 720-4486

Effective February 2008

I. ITEM DESCRIPTION

Item –	<u>Lean Beef Patties</u> - This item consists of ground beef with added ingredients made into 3.1 oz. patties and Individually Quick Frozen (IQF).
Meat Component –	Beef will comprise of at least 85 percent of the raw formula.
Non-Meat Component –	Non-meat components will comprise no more than 15% of the raw formula.
Fat –	Fat will be 4 grams per 88 gram (3.1 oz.) serving.
Packing –	Four (4) 10-pound, five (5) 8-pound, or eight (8) 5-pound primary containers (packages) will be packed in a 40-pound (net weight) shipping container.
Delivery Unit –	Each delivery unit will consist of 950 cases and 38,000 pounds.

II. CHECKLIST OF REQUIREMENTS

All items must be produced in accordance with Food Safety and Inspection Service (FSIS) regulations and the checklist of requirements. The contractor's production plan, submitted to the Contracting Officer, must adhere to the following checklist requirements.

A. MATERIALS

1. MEAT COMPONENT

Beef will be the only meat component allowed.

- a) Domestic Origin of Meat Component – All beef will be from cattle that originate from U.S. produced livestock as defined in Announcement LS-120.
- b) Harvest - Boneless beef shall be derived from cattle harvested at facilities that comply with the following origin and harvest requirements.
 - (1) Humane Handling – All cattle shall be humanely handled in accordance with all applicable FSIS regulations, directives, and notices.
 - (2) Non-Ambulatory Disabled Cattle – Meat from carcasses of non-ambulatory disabled cattle will not be included in USDA purchased ground beef products.
 - (3) Spinal Cord Removal – All spinal cord tissue shall be removed during the harvesting process.

- (4) Pathogen Intervention Steps – The harvest process must include at least two pathogen intervention steps. One of the intervention steps shall be steam pasteurization, an organic acid rinse, or a 180°F hot water wash and must be a critical control point (CCP) in their FSIS recognized slaughter process Hazard Analysis Critical Control Point (HACCP) plan.
- (5) Carcass Testing - Routinely test carcasses for *E. coli* O157:H7 to verify effectiveness of interventions at CCP.
- c) Boneless Beef – Boneless beef must comply with the following requirements:
 - (1) Handling – All boneless beef must be maintained in excellent condition. Frozen boneless beef may be used provided it is processed into the final product within 60 days from the date of pack.
 - (2) Objectionable Materials – The following objectionable materials shall be excluded:
 - (a) Major lymph glands (*prefemoral*, *popliteal*, and *prescapular*), thymus gland, and the *sciatic* (*ischiatric*) nerve (lies medial to the outside round).
 - (b) All bone, cartilage, and the following heavy connective tissues:
 - White fibrous – Shoulder tendon, elbow tendon, silver skin, *sacrociatic* ligament, opaque *periosteum*, *serous* membrane (*peritoneum*), tendinous ends of shanks, *gracilis* membrane, *patellar ligament* (associated with the *stifle joint*), and *achilles* tendon.
 - Yellow elastin – Back strap and *abdominal tunic*.
- d) Mechanical Separation – Beef that is mechanically separated from bone with automatic deboning systems, advanced lean (meat) recovery (AMR) systems, or powered knives will not be allowed.
- e) Finely Textured Beef (FTB) – FTB may be used at a rate not to exceed 15% of the meat component. The producer of finely textured beef shall assure that the product has a discernible redness in color. The finely textured beef shall maintain the same redness in color until the time of blending and grinding to minimize the effect of the color to the finished beef patties. Fat content of the FTB shall not exceed 10% percent fat. The contractor shall document all procedures for handling of finely textured beef trimmings and must use it within 60 days of the date of production.
- f) Microbial Testing – The contractor will assure that all boneless beef, including finely textured beef, must be tested for presence of *E.coli* O157:H7 and salmonella. All production lots of boneless beef associated with positive test results for pathogens shall not be allowed within USDA destined ground beef products.

2. NON-MEAT COMPONENTS

Non meat components, not to exceed 15 percent by weight, will be used to enhance the palatability of the patties. The contractor's production plan must list all ingredients (i.e., water, processing aids, binders, seasonings, etc.) within their formula.

B. PROCESSING

1. GRINDING AND BLENDING

- a) Grinding - Boneless beef and FTB shall be ground twice, with the final grind passing through a 1/8 inch grinding plate. Blending after final grinding is allowed only to the extent that it doesn't affect the appearance of the finished beef patties.
- b) Bone Collector / Extruder System - A bone collector/extruder system must be in operation to remove bone, cartilage, and heavy connective tissue during the final grind.

2. PATTY WEIGHT, THICKNESS, SHAPE, AND COLOR

- a) Patty weight – Target weight will be 3.1 ounces. Acceptable weight tolerance range will be 3.0 to 3.2 ounces.
- b) Patty thickness – 5/16 inch (+/- 1/16).
- c) Shape - Patties shall be round in shape and waffled or scored on both sides.
- d) Color – Color of patties shall be monitored for normal appearance and color. When cooked to an internal temperature of 160°F by the end user, patties with internal or external pink appearance will not be allowed.

3. STATE OF REFRIGERATION

- a) Individually Quick Frozen (IQF) – Patties will be IQF to 10°F or below prior to packaging and then frozen to 0°F or lower within 24 hours after completion of packaging and packing of the lot. Patties will not stick together after they are packaged and packed.
- b) Handling – Patties be stored, shipped, and delivered at temperatures that do not exceed 0°F.

4. METAL DETECTION

All products will be free of metal contaminants. Detection of stainless steel, ferrous, and non-ferrous (e.g., lead, copper, and aluminum) metals is required.

C. FINISHED PRODUCT LIMITATIONS

1. FAT

The contractor will target production so that the fat content of the finished product will be 5 percent (4 g fat per 88 g (3.1 oz.) serving). The declared fat content (as packaged) will be stated on the nutrition facts panel on each shipping container label according to FSIS nutritional labeling regulations.

2. MICROBIAL

Production lots of beef patties will not be allowed delivery to USDA when results meet or exceed the upper specification limits within the table below.

- a) Microbial Testing – All lots of beef patties will be tested for all microbes listed in the table below after final grinding and before freezing. All samples will be sent to an AMS designated laboratory (ADL).

- (1) Sample Preparation - From each lot of finished product (patties), a composite sample will be prepared from at least 4 randomly selected samples (of approximately equal size) of finished beef patties. The samples shall be blended. From the mixture, a single sample shall be submitted to the ADL for analysis. A reserve sample shall be drawn and held for testing in the case that the Contracting Officer deems it necessary.
- (2) Testing and Results - The sample will be analyzed by the ADL for all microbes listed in the table below.

Except for E. coli O157:H7, the applicable test methods listed in the Compendium of Methods for the Microbiological Examination of Foods (current edition), published by the American Public Health Association. The results will be recorded and plotted by the ADL on control charts and histograms for all microorganisms as illustrated in Appendix A.

- b) Testing for E. coli O157:H7 – The beef sample submitted to the ADL will also be tested for the presence of E. coli O157:H7 using the referenced test methods that are within or conform to the "USDA/FSIS Microbiology Laboratory Guidebook (http://www.fsis.usda.gov/Science/Microbiological_Lab_Guidebook/index.asp), Chapter 5.03" for Detection, Isolation, and Identification of Escherichia coli O157:H7 and O157:NM (Nonmotile) from Meat Products, Effective Date 10/25/02.
- (1) FSIS Notification for presence of pathogens - When presence of E. coli O157:H7 or salmonella is positive:
 - (2) The ADL will notify FSIS.
 - (3) FSIS will be notified by the contractor for final disposition of the product. The contractor shall conduct a cause and effect analysis to determine the appropriate corrective action necessary to eliminate the probable cause. The corrective actions must be implemented and proven effective.
- (d) The ADL will report all results to the contractor and AMS.

AMS MICROBIAL REQUIREMENTS FOR GROUND BEEF TABLE	
Microbial Test	Upper Specification Limits
Standard Plate Count	100,000/gram
Total <i>Coliforms</i>	500/gram
<i>E. coli</i>	100/gram
<i>Salmonella</i>	Positive Results/25 grams
<i>E. coli</i> O157:H7	Positive Results/325 grams

D. PREPARATION FOR DELIVERY

1. PACKAGING AND PACKING

- a) Packaging - Patties must be placed into four 10-pound, five 8-pound, or eight 5-pound flexible (plastic) vacuum packaged or sealed containers and placed into each shipping container. Hand twisting or hand tying is not acceptable. Separation material between patties is not required provided the IQF patties do not stick together at the time of shipment.
- b) Packing - Only one style and size of shipping container may be used in any one delivery unit. Closure will be closed by strapping, taping or gluing. When strapping is used, the initial closure (usually the bottom of container) shall be secured by the gluing or taping method.
- c) Net Weight – 40 pounds per shipping container. Using SPC tools, the contractor shall verify the marked net weight.
- d) Marking Of Containers - Both immediate and shipping containers will have a printed code that includes the establishment number and is traceable to the production lot and date. Shipping container markings shall include all information required by FSIS along with the additional information listed below:
 - (1) USDA Shield (at least 2 inches high and appearing on the top of the shipping container or on the principle display panel).



- (2) Applicable Contract Number.
 - (3) The product name, "Lean Beef Patties" with an ingredient statement
 - (4) Product code: A580
 - (5) A Statement: "For Institutional Use Only".
 - (6) Nutritional Facts Panel
- e) Palletized Unit Loads – All products shall be stacked on new or well-maintained pallets and palletized with shrink wrap plastic.

E. DELIVERY UNIT

The delivery unit shall be 38,000 (950 shipping containers).

F. PRODUCT ASSURANCE

1. WARRANTY AND COMPLAINT RESOLUTION

- a) Warranty – The contractor will warrant that the product complies with all specification requirements, production plan declarations, and provisions set forth in the program announcement.
- b) Complaint Resolution – Customer complaint resolution procedures will be included in the production plan. These procedures will include: a point of contact, investigation steps, intent to cooperate with AMS, and product replacement or monetary compensation. The procedures will be used to resolve product complaints from recipient agencies or AMS.

2. NON-CONFORMING PRODUCT

The contractor must have documented procedures that assure nonconforming product identification, segregation, and disposition in order to prevent misuse and that nonconforming product is not delivered to USDA. The contractor will ensure that product which does not conform to product requirements is identified and controlled to prevent unintended use or delivery.

3. AMS MONITORING AND PRODUCTION ASSESSMENT

An AMS Meat Grading and Certification Branch agent must be present during the production of the finished product. The AMS agent will monitor and verify the processing steps, quality assurance activities, and corrective actions to assure that all requirements outlined in the approved production plan are complied with. The AMS agent will be conducting the monitoring and production verification in accordance with applicable MGC instructions. Any deviations to contractual requirements will be reported to the contractor and Contracting Officer.